

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

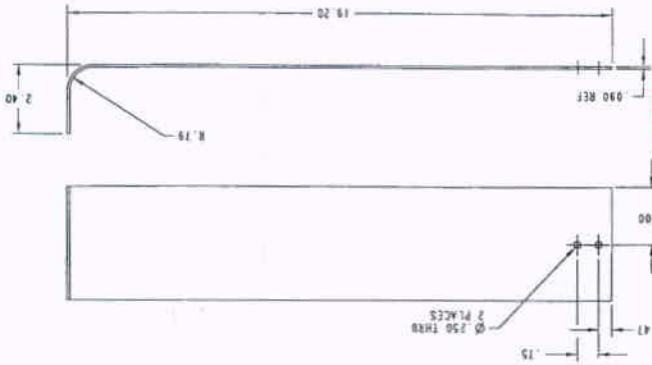
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

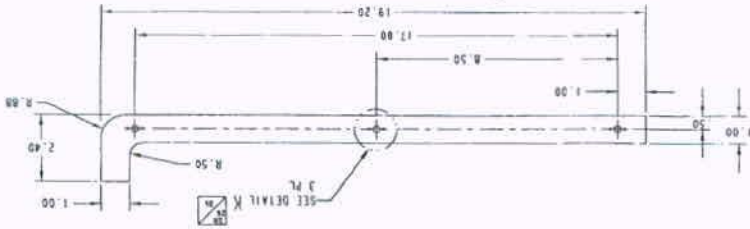
ORIGINAL

PREMIER AVIATION, INC.
3000 AVIATION PARKWAY, GRAND PRAYERS, TEXAS 75042
DISTRIBUTION NO. B67-43001
SCALE 2:1

② -147 SUPPORT PLATE
MATERIAL: 090 TIR, 5081-16, 00-A-250/11
SCALE 0:500



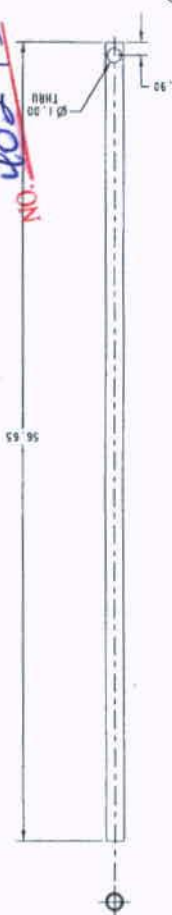
③ -149 SIDE PLATE
MATERIAL: 090 TIR, 5081-16, 00-A-250/11
SCALE 0:500



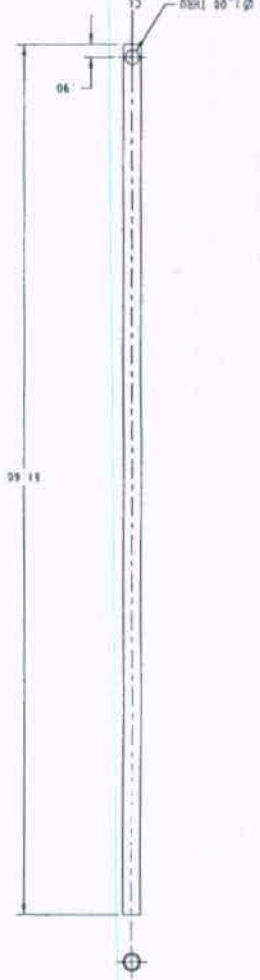
④ -155 PIN
MATERIAL: 250 BND, 303 SS
SCALE 2:500



⑤ -259 INNER TUBE
MATERIAL: 1:25 00 X 1:25 WALL, 5081-16, 00-A-250/11
SCALE 0:250



⑥ -255 INNER TUBE
MATERIAL: 1:25 00 X 1:25 WALL, 5081-16, 00-A-250/11
SCALE 0:250



NO. 40243
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING COPY
RETURN TO
SHOP COPY

RELEASED
-7-06-01-70

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 7/4/2008 8:45:43 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 90 DEGREE BLADE SUPPORT ASSY

Job Number: 40243

Part Number: PB674300167

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble as per dwg B67-43001

GP 08/07/22 (6)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/22 (+6)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *W/A*

08.07.24

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/08

Job Completion



08.08.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: B67-4301-167 PAR #: NA Fault Category: Prod/Prod. Large NCR: Yes No DQA: JD Date: 08/04/08
 QA: N/C Closed: JD Date: 08/28/08

NCR: <u>40243</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/10	#70	welds were found to be inspect inadequate inattique along the 2.40" Dm. All parts affected QTY (110)	<u>JD</u> 08.07.14	Re weld the length of the Dm. 2.40" from Dwg. B67-4300-147/-149. AS per Q57004.	<u>JD</u> 08.07.14	<u>S</u> 08/04/15	<u>JD</u> 08.07.14	<u>S</u> 08/04/15
				Grind welds flush.	SAP 08/07/14	<u>S</u> 08/07/15		
				Re Alumin as per Q57005	<u>JD</u> 08/07/16	<u>S</u> 08/07/16		<u>S</u> 08/07/15

NOTE: Date & initial all entries

Date: Friday, 7/4/2008 8:45:43 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 90 DEGREE BLADE SUPPORT ASSY

Job Number: 40243

Part Number: PB674300167

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

PB6743001-147

INSPECT WORK TO CURRENT STEP



B 40024



Comment: INSPECT WORK TO CURRENT STEP

7.0

PB6743001149

Side Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Side Plate

B20025

08.07.03

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: Weld assembly as per dwg B67-43001

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/07/07 (x13)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/07/07 (x13)

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08/07/16 (x13)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/07/16 (x13) P10

13.0

MS21075L3

Nutplate



Comment: Qty.: 6.0000 Each(s)/Unit Total: 60.0000 Each(s)

Nutplate

M108601

08/07/17

14.0

MS20426AD34

RIVET



Comment: Qty.: 12.0000 Each(s)/Unit Total: 120.0000 Each(s)

RIVET

M105978

08/07/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Date: Friday, 7/4/2008 8:45:43 AM
User: Kim Johnston

Process Sheet

SPLIT.

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 90 DEGREE BLADE SUPPORT ASSY
Job Number	: 40243 -1	Part Number	: PB674300167
Estimate Number	: 13386	Drawing Number	: B6743001 PAGE24
P.O. Number	:	Project Number	: N/A
This Issue	: 7/4/2008 S.O. No. :	Drawing Revision	: B1
Prsht Rev.	: NC	Material	:
First Issue	: 1/1 Type : SMALL /MED FAB	Due Date	: 7/10/2008
Previous Run	: 40024	Qty:	10 Um: Each
Written By	: <u>HA 08 07.04</u>		
Checked & Approved By	: <u>HA 08 07.04</u>		
Comment	: Est Rev.A 08-06-19 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S090	6061-T6 .090 Sheet
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Comment: Qty.: 0.6241 sf(s)/Unit Total : 6.2412 sf(s)
6061-T6 .090 Sheet
batch: ~~2572221~~

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg B67-43001-147
Dwg Rev: B1
Prog Rev: _____
2-Deburr if necessary

Handwritten signature/initials

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: Form as per dwg B67-43001